

Patent claims

1. A method for the production of press-hardened components, in particular a vehicle body component, from a semifinished product (2) made of unhardened, hot-workable steel sheet, characterized in that the following method steps are carried out:
  - a component blank (10) is formed from the semifinished product (2), pre-coated with a first coating (33), by a cold-forming method, in particular a drawing method;
  - the component blank (10) is trimmed at the margins to a marginal contour (12') approximately corresponding to the component (1) to be produced;
  - the trimmed component blank (17) is heated and press-hardened in a hot-forming tool (23);
  - the press-hardened component blank (18) is covered with a second, anticorrosion coating (34) in a coating step.
2. A method for the production of press-hardened components, in particular a vehicle body component, from a semifinished product (2) made of unhardened, hot-workable steel sheet, characterized in that the following method steps are carried out:
  - the semifinished product (2) pre-coated with a first coating (33) is heated and press-hardened in a hot-forming tool (23);
  - the component blank (10') press-hardened in this way is trimmed at the margin to a marginal contour (12) corresponding to the component (1) to be produced;
  - the press-hardened component blank (18') is covered with a second, anticorrosion coating (34) in a coating step.
3. The method as claimed in claim 1 or 2, characterized in that the coating (34) is applied to the press-hardened blank (18, 18') by a hot galvanizing process.
4. The method as claimed in claim 1 or 2, characterized in that the coating (34) is applied to the press-hardened component blank (18, 18') by a thermal diffusion process.

5. The method as claimed in at least one of the preceding claims, characterized in that the coating (34) is deposited on both the pre-coating (33) and uncoated regions of the component blank (18, 18').
6. The method as claimed in at least one of the preceding claims, characterized in that the coated component blank (18, 18') is freed of residues of the coating step after the coating step.
7. The method as claimed in at least one of the preceding claims, characterized in that the coated component blank (18, 18') is tempered after the coating step.
8. A press-hardened component, in particular a vehicle body component, consisting of a semifinished product (2) made of unhardened, hot-workable steel sheet provided with an anticorrosion coating (33), characterized in that it is produced according to the method as claimed in at least one of the preceding claims.
9. The press-hardened component as claimed in claim 8, characterized in that a covering consisting of a first, aluminum-containing coating (33) and a second, zinc-containing coating (34) arranged over it is deposited on the component.